Work Order ID 116834 *116834* Page 1 April-24-14 7:50:37 AM D3488-041 Item ID: Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Blade Fitting LH Start Date: 4/23/14 **Start Qty: 12.00** *12* **Cust Item ID:** Required Date: 4/23/14 Req'd Qty: 12.00 *12* **Customer:** Reference: Run Date: M-W-25 Tooling: Process Plan: MLJ **Approvals:** Date: Stop Date: SPC (Y/N): Date:_ Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** D3488 Rev B DSK101 REV D 100 0.00 DAS DOOSAN LATHE *100* Doosan 0.00 Memo Doosan Lathe 1-Turn as per Dwg DSK 101 & Folio FA625 4 2-Deburr QC2- Inspect parts off machine FAI/FAIB 110 0.00 *110*

0.00

Memo

Quality Control ...

DQA:			Date:										
						WORK ORDER NON	-CO	ONFO	RMANCE / U	PDATE			AEROSPACE
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	_	Marks/Ch				Drill Holes	\vdash	Off-set					
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		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

Work Order ID 116834 *116834* Page 2 April 24-14 7:50:37 AM Item ID: D3488-041 Accept *N900040100* Setup Start **Revision ID: Item Name:** Blade Fitting LH **Start Date: Start Oty: 12.00** *12* 4/23/14 **Cust Item ID:** Required Date: 4/23/14 Req'd Qty: 12.00 *19* **Customer:** Reference: Run **Approvals:** Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Insp. Accept **Work Center ID Description Run Hours** Code Qty Qty Number Stamp 120 0.00 DAS 02 9-89 ET 14-05-16 HAAS CNC VERTICAL MACHINING #1 *120* HAAS'1 0.00 Memo HAAS CNC vertical machine #1 1-Machine as per Folio FA625 & Dwg D34882-Deburr DAS 130 QC2- Inspect parts off machine FAI/FAIB 0.00 02 9-80 ET 14-05-16 *130* QC 0.00 Memo Quality Control 140 QC8- Inspect parts - second check 0.00

0.00

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140

Quality Control

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116834

Page 3

April-24-14 7:50:37 AM Item ID: D3488-041 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Blade Fitting LH *19* **Start Date:** 4/23/14 **Start Otv: 12.00 Cust Item ID:** Required Date: 4/23/14 Rea'd Otv: 12.00 *10* Customer: Reference: Run Date: Approvals: Process Plan: Tooling: Date: Stop Date:_ ' F . SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID **Description Run Hours** Code Qty **Qty** Number Stamp 150 Chemical Conversion Coat per OSI005 4.1 0.00 *150* HandFinish 0.00 Memo Hand Finishing White Gloss(Ref:4.3.5.1) per OSI095 435 160 0.00 D & 14-6-21. *160* Powdercoat Powder Coating 170 QC3- Inspect Part Finish 0.00 OC 0.00 Memo Quality Control

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116834

Page 4

April-24-14 7:50:37 AM Item ID: D3488-041 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Blade Fitting LH *12* **Start Date:** 4/23/14 **Start Oty: 12.00 Cust Item ID:** Required Date: 4/23/14 **Reg'd Oty:** 12.00 *12* **Customer:** Reference: Start Run **Approvals:** Process Plan: Date: _____ Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Insp. Accept **Work Center ID Description Run Hours** Code Qty **Qty** Number Stamp 180 0.00 HandFinishing *120* HandFinish 0.00 Memo Hand Finishing __Install Inserts as per Dwg D3488 190 QC5- Inspect part completeness to step on W/O 0.00 12 \$ 14.77. *190* OC Memo 0.00 Quality Control Identify as per dwg & Stock Location: FP.001 200 YIZLHI & lalason *200* Packaging 0.00 Memo Packaging

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Work Ord		16834		*116	3834*						Page 5
Item ID: Revision ID: Item Name:	D3488-041 Blade Fitting			Accept	*N900	040	100*	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	4/23/14 e: 4/23/14	Start Qty: 12.00 Req'd Qty: 12.00	*1 <i>2</i> * *1 <i>2</i> *		Cust Item I Customer:	D:				IVI	17
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):		nte:		Run	Start Stop		R1* R2*
Sequence ID/ Work Center 1 210	I D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Ad Code Q		-	Reject Number	Insp. Stamp

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Quality Control

MLJ 14-07-08

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		Wave/Tw	ist in Tub	e	- 1	Fit/Function		Out of S	Sequence				

Picklist Print

April-24-14 7:50:42 AM

Work Order ID: 116834

116834

Parent Item:

D3488-041

D3488-041

Parent Item Name:

Blade Fitting LH

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-02-28 JLM

IPP Rev:B As per Rev B 06-03-30 JLM

IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225	AELS8-1032-225	Purchased	No				Each	1,177.000		48			
AI S7-103	32-225	4							**	M	1.1	070	4
				Location	<u>n</u>	Loc	<u>Oty</u>	Loc Code					
				FG			80		_				
					118520		80						
				FP001			1000		_				
					m128649/	:	1000		****				
1				ST280			97		_	×48			
					m128179		97		_				
D6103-003		Manufactured	No				Each	20.0000		12		. /	
D6103-00 Round Billet, Aluminum).3								**		1	4-5	-03
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DART AEROSPACE LTD	Work Order:	116834
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2	Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
		l	ne Section	<u> </u>	<u> </u>	<u></u>
Ø2.150	+/-0.005	2.155			T-G-Yein	JL-10
Ø2.780	+/-0.005	2719	/		Vern	CNC-QS
Ø3.125	+/-0.010	3-124	/.	•	, <u> </u>	
Ø3.346	+/-0.010	3.347			vern	JL-10
0.125 x 45°	+/-0.010 x +/-0.1°	-125x45°			~	
8.000	+0.030/-0.000	8-015			Vein	CNC-OR
9.250	+/-0.010	9-250				1
0.188	+/-0.010	-188				
R0.032	+/-0.010	-032				
R0.062	+/-0.010	.062				
Ø0.297	+0.005/-0.001	299				·
Ø0.430	+/-0.010	.431				
0.100	+/-0.010	-101				
0.125	+/-0.010	128				
2.620	+/-0.010	2615				_'
3.500	+/-0.010	3.500			H-(-	
1.005	+/-0.010	1005			<i>(</i>	
Ø0.484	+0.005/-0.001	486				
1.180	+/-0.010	1,180				
3.150	+/-0.010	3.150			7	
3.070	+/-0.010	3.070				
R0.063	+/-0.010	-063				

DART AEROSPACE LTD	Work Order:	116834
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2	Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
		Milli	ng Section	1		
Ø0.508	+0.006/-0.001	0.510			مىس	PT-4
0.750	+/-0.010	0.755				
1.500	+/-0.010	1.497				31006
11.18	+/-0.030	11.175				
R0.062	+/-0.010	0.062				
0.125	+/-0.010	0.16				
0.590	+/-0.010	0.590				
0.793	+/-0.010	0.798				
1.351	+/-0.010	1.344				
1.317	+/-0.010	1.325				
1.802	+/-0.010	1.798				

r		nas		
Measured by:	DAS 02	Audited by: 37	Prototype Approval:	N/A
Date:	14 05 - 95	Date: 14.65.26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
В	08.09.19	Reformat P/O D3488	3-041 KJ/JLM 1.0	21
С	08.12.02	Dimension 8.000 removed	KJ/JLM 🚓	

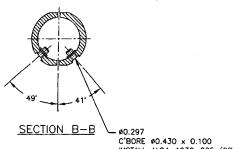
		ı	ı		_				
	Wassel M	il 15.09 th						DART	
9.250	**	*					,	7	
— 8.000 + 0.030	D	С	В	Α	06.	DATE	CHEC	DESIG	
		<u> </u>			05.09	174	KED #	PH	
0.040+0.000	06.05.09	06.04.17	06.03.02	05.12.21		411	APPROVED	DRAWN BY	
R0.032	 	0.188 W		NEW ISS	D3488-1	TITLE	DRAWING NO. DSK 101	1	,
KU.U02	DIAMETER	/AS 0.125	ERANCES	SUE	/-2 TUR			AEROS PORT	
75—T7351 ROUND BAR PER QQ—A—225/9 : M7075T73R)			AND RAD		NING DET			PACE HADLOCK, WA	
0.020	AMFER	-	DIUS		AIL		SH	USA,	
ESS OTHERWISE NOTED					1:3	SCALL	rev. (eet 1 of		
	_	_	_		3				

(REF. DART MATERIAL SPEC M7075T7 NONE ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHER MAKE FROM ALUMINUM 7075-T7351 BREAK UNMARKED SHARP EDGES 0.010 TO 0.020 ø2.150±0.005 0.125 X 45~ CHAMFER ø3.346 -\$2.780±0.005 --FINISH: **DSK 101** 354G

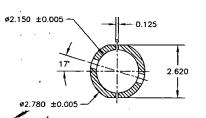
(B)

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INSTALL ALS4-1032-225 (OR AKS4-1032-225 OR ALS7-1032-225 OR AKS7-1032-225) INSERTS AFTER FINISH (4 PLACES)



D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

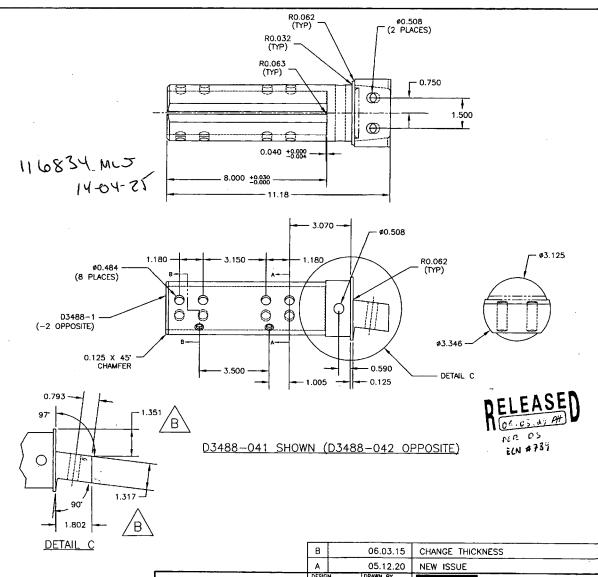
QTY -041	-042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1	1.	D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225	INSERT
	. 1	or AKS7-1032-225	

D3488-041/-042 BLADE FITTING MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R) ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

ED SHARP EDGES 0.010 TO 0.020 FTER POWDER COAT

IN INCHES

DART QSI 018 UNLESS OTHERWISE NOTED



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DESIGN DART AEROSPACE USA, INC. PH DART CHECKED D3488 SHEET 1 OF DATE SCALE 06.03.15 BLADE FITTING

